

Work Order ID 73218

Friday, August 26, 2011 10:25:41 AM



Page 1

Item ID: D3561-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seal Insert Tool

Start Date: 8/26/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 11/08/26 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3561

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3561 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

304 . 178

B11-8-29

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-29

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 6/29

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73218

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Page 2

Item ID: D3561-1

Revision ID:

Item Name: Seal Insert Tool

Start Date: 8/26/2011 Start Qty: 10.00

Required Date: 9/9/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

N/A

Deburr if necessary.

140



Brake NC

NC BRAKE

Memo

0.00

0.00

Sublog

Form as per Dwg D3561

①

150



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sublog

①

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

Item ID: D3561-1

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Setup Start



Revision ID:

Stop



Item Name: Seal Insert Tool

Start Date: 8/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 8T67

0.00



Packaging

Memo

0.00

Packaging

[Handwritten signature] *(11X)* *SP 11-09-06*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11

ME 11-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

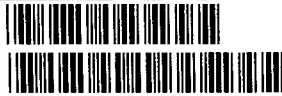
Friday, August 26, 2011 10:25:39 AM

Page 1

Work Order ID: 73218

Parent Item: D3561-1

Parent Item Name: Seal Insert Tool



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: ☐A☐06.10.19☐New issue☐EC☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

55.0000

0.0473

0.497895



304/316 0.125 Sheet



B11-8-29

Location

Loc Qty

Loc Code

MAT020

55

117494

55

117494

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A
SHEET 1 OF 1
SCALE
1:1

DRAWING NO.
D3561

TITLE
SEAL INSERT TOOL

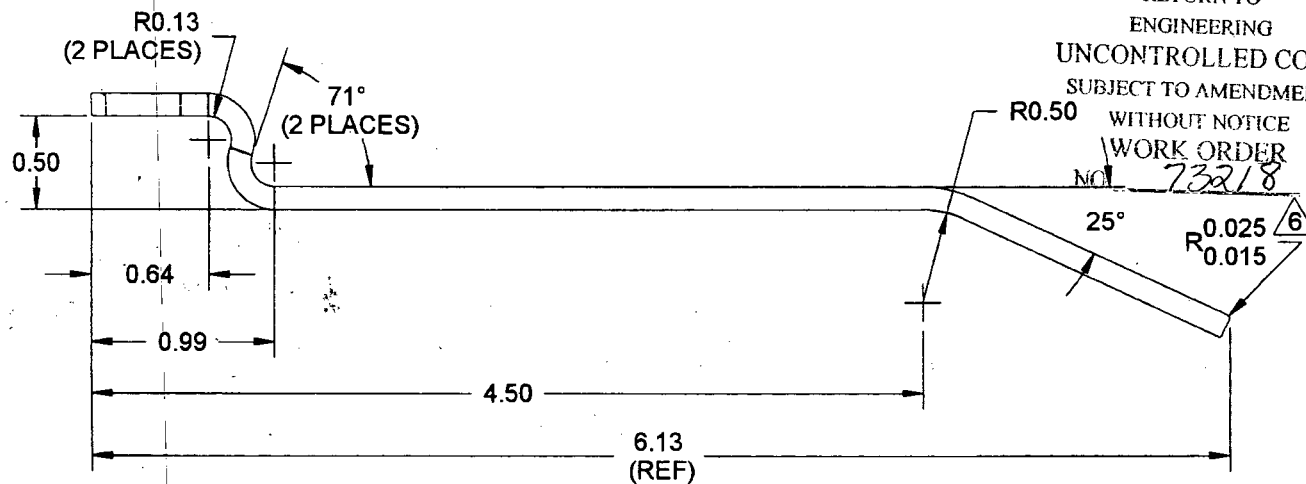
DESCRIPTION

NEW ISSUE

DESIGN BY
CHECKED
DATE
06.10.06

REV. A
DATE
06.10.06

DART

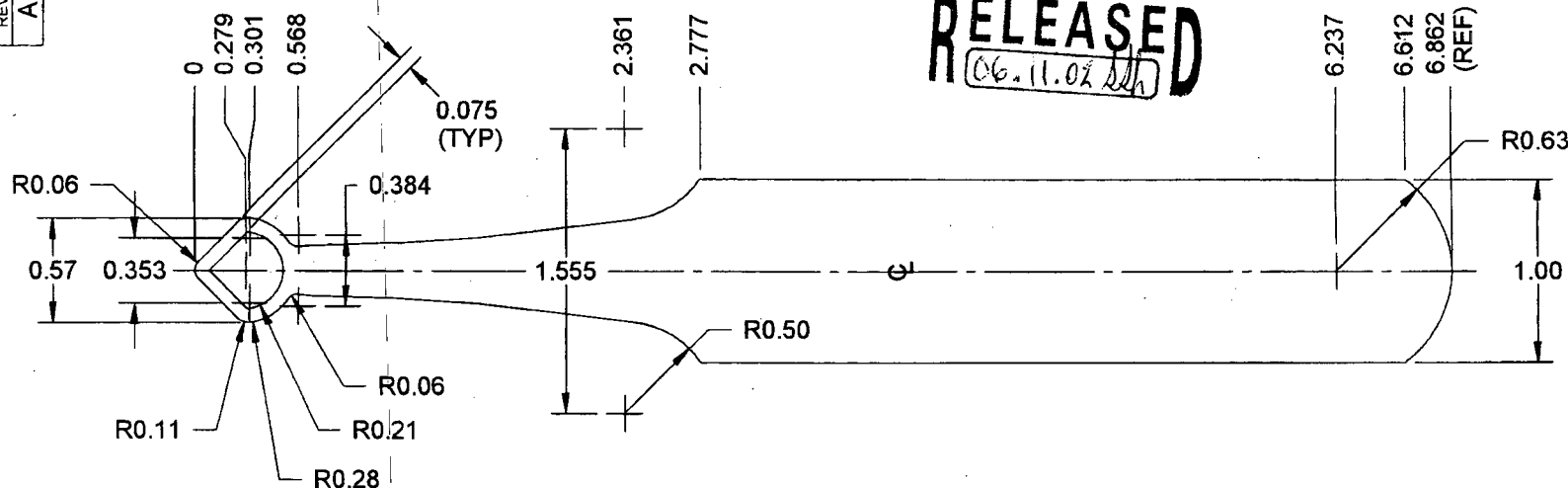


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73218

D3561-1 SEAL INSERT TOOL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



D3561-1F SEAL INSERT TOOL FLAT PATTERN

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